



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11657	32/42/66
2	Machined By		V.T.L. H/c Shop	34/44/66
3	Pallet Die No.		12037 (8.0) H/c	1 Drg No., 68.0 609
4	Die Category	Drg. No.	M-Jumbo	Revol
5	Out Side Diameter	Drg. No.	680.7 H/c	Step 002 693 H/c Tapper 8°
6	Inside Diameter	Drg. No.	548.12 H/c	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut. 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c	(4 x 8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 3 H/c
10	Drilling Area Surface Smoothness		ok	Back Both Side
11	Tapping Operator		H/c Shop	Tapping No. of Holes, 4 Both Side
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		H16 = Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 33.7 H/c	Tapping Depth, 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/4/24	
1	As per programme no.		_____	
2	Gun Drilling Work Completed On		_____	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		OK	Counter 20
2	External Relief Dia		Ist Pad 8.5 H/c 34 H/c	Row 10
3	External Relief Depth		9.0 H/c 34 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ferrace	
6	Material Sent For Hardening On Date		4 4 24	
Inspected By (Sign) & Date			Ravi 4/4/24	

Reviewed by (Engineer-CNC)

Manager-QA